

Date: Thursday, 24/07/2008 8:23:49 AM
 User: *Melanie Fauteux

Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40608 -1A
 Estimate Number : 13433
 P.O. Number :
 This Issue : 24/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 17/07/2008 Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By : MF 05-07-24
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
 Part Number : PB674300115
 Drawing Number : B6743001 P.7
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 24/07/2008 Qty: 35 Um: Ea

(2)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001257 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube

batch: 40585

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing

batch: 112141

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340045

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340053

5.0 PB674300171 PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-71

batch: 340027

24/07/2008 8:23:49 AM
Anie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

Handwritten: 08-07-24

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08-01-27

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08-07-24

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELICAL INSERT

Handwritten: M 17935

Handwritten: 08-07-24

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

Handwritten: BK 08-07-30

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08-07-24

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Handwritten: M102316

Handwritten: (5X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Handwritten: 08/07/31

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40 OF
 380
 2:10

M.H.

08/07/31

(5X)

14.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD

08/07/31

5

15.0

PB674300173



20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

14

08.08.24

16.0

PB674300183



PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

14

08.08.24

17.0

MS27039110



Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: 108986

14

08.08.24

18.0

NAS1149F0316P



WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: 108473

14

08.08.24

19.0

SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

14

08.08.24

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50609/402

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 509

8/9/12 2x SP

22.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/15

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-12

Job Completion



